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de Oliveira Antunes et al.

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(54) **INJECTION MOLDING FLOW CONTROL APPARATUS AND METHOD**

(71) Applicant: **Synventive Molding Solutions, Inc.**,
Peabody, MA (US)

(72) Inventors: **Sergio Ribeiro de Oliveira Antunes**,
Scottsdale, AZ (US); **Christian Gotz**,
Bensheim (DE); **Juergen Wilhelm**
Emich, Gross Zimmern (DE)

(73) Assignee: **Synventive Molding Solutions, Inc.**,
Peabody, MA (US)

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(58) **Field of Classification Search**

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See application file for complete search history.

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Primary Examiner — James Sanders

(74) *Attorney, Agent, or Firm* — Polsinelli PC

(57) **ABSTRACT**

An apparatus for controlling the rate of flow to a mold cavity including a controller instructing a valve system to drive an actuator and a valve pin and including instructions that instruct the valve system to drive an actuator and a valve pin and including instructions that instruct the valve system to move from a start position to one or more intermediate drive rate positions and subsequently from the one or more intermediate drive rate positions to a high drive rate position on receipt by the controller of a signal from a position sensor that is indicative of the valve pin having reached a second position.

14 Claims, 13 Drawing Sheets

